

Work Order ID 138088

Friday, October 23, 2015 2:41:24 PM

138088

Rev A Draw 5.7.10.09
~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5324-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM



Stop

NS2

Item Name: Drag Bracket

Start Date: 10/23/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: OCT 20 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5324	<u>A2</u> <i>Rev A 5.7.10.09</i>								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A2</u> Prog Rev: <u>A2</u> 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

NOV 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER :							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Work Order ID 138088***138088***

Page 3

Friday, October 23, 2015 2:41:24 PM

Item ID: D5324-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Drag Bracket
Start Date: 10/23/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/23/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-11-27

POSITIVE RECALL

EFFECTIVE 10/26/15 AUTH MLJ
RELEASED 1761/02 DATE 8

RD15-1016-01

Rev & Drawn attached

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Picklist Print

Page 1

Friday, October 23, 2015 2:41:27 PM

Work Order ID: 138088

138088

Parent Item: D5324-1

D5324-1

Parent Item Name: Drag Bracket

Start Date: 10/23/2015

Required Date: 10/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No				sf	50.3000		0.013684			

M304S12GA

304/316 0.100" Sheet

**

10/15/11/17

Location

Loc Qty

Loc Code

MAT019

50.3

m131322

50.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

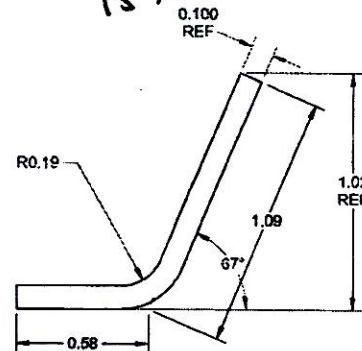
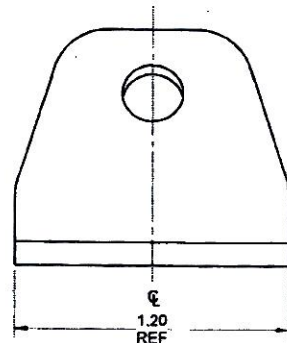
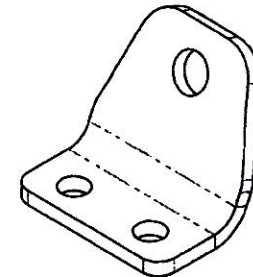
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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OTHER :																																																																																			

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 138088 MLJ
1570-26



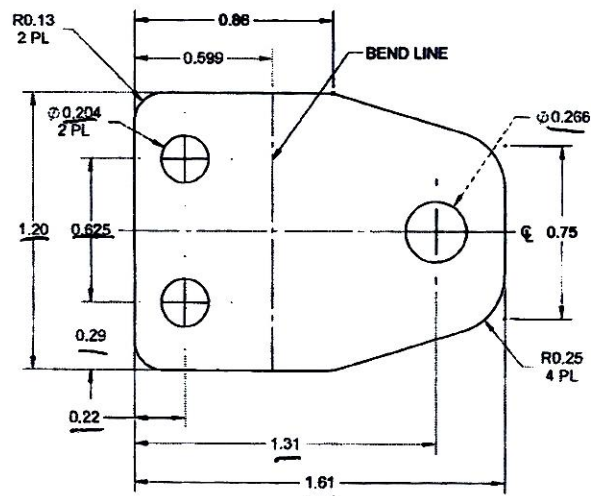
D5324-1 DRAG BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D5324-1F FLAT PATTERN
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

PRELIMINARY ISSUE

A NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5324	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DRAG BRACKET	NTS
DATE	15.08.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



D5324-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET, 0.100 THK, ANNEALED 2B
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S12GA OR M303S12GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5324	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DRAG BRACKET	NTS
DATE	15.08.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Wednesday, January 21, 2015 10:13:32 AM

All amounts are calculated in domestic currency.

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Bank Amt
VendorID\Vendor Name		VC-COP001	Thyssenkrupp Materials CA Ltd								
PO26885	1		M304S12GA	SF	1/16/2015	1/21/2015	96.0000	\$7.26	0.0000	0	\$696.77
CAD	No		304/316 0.100" Sheet	SF	96.0000	DCUSER		\$696.77	0.0000	0	
			m131322								
	3		M6061T6S.063	SF	1/16/2015	1/21/2015	96.0000	\$2.07	0.0000	0	\$198.26
	No		6061-T6 .063 Sheet	SF	96.0000	DCUSER		\$198.26	0.0000	0	
			m131322								
	4		M7075T6S.050	SF	1/16/2015	1/21/2015	48.0000	\$3.58	0.0000	0	\$171.75
	No		7075-T6 SHEET .050	SF	48.0000	DCUSER		\$171.75	0.0000	0	
			m131322								
Total Received Quantity:										240.0000	
Total Qty to Inspect (PO U/M):										0.0000	
Total Reject Quantity:										0.0000	
Total Receipt Value:										\$1,066.78	
Total Balance Due Quantity:										0.0000	

B I L L O F L A D I N G
Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

No: PEC 914889
Ship Date 19Jan15 at 11:38 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp CARMELA AGNIHOTRI(905-5321422)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

① Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G
1) Our Order PEC-755265- 1 Your PO # PO26885
Part # M304S12GA
Rel # CHANTAL

STAINLESS STEEL SHEET 304-2B
1050 Nom X 48.0000" X 96.0000"
AS PER ASTM A240

Heat Number Tag No
A2400889 371518

Quantity PCS
96.00 SFT 3

Wt LBS
421

MTR

2) Our Order PEC-755265- 2 Your PO # PO26885
Part # M304S16GA
Rel # CHANTAL

STAINLESS STEEL SHEET 304-2B
0600 Nom X 48.0000" X 96.0000"
AS PER ASTM A240

B70

3) Our Order PEC-755265- 3 Your PO # PO26885
Part # M6061T6S.063
Rel # CHANTAL

ALUMINUM SHEET 6061 T6
0640 Nom X 48.0000" X 144.0000"
AS PER ASTM B209

Heat Number Tag No
24943/01/00 371525

Quantity PCS
96.00 SFT 2

Wt LBS
86

MTR

4) Our Order PEC-755265- 4 Your PO # PO26885
Part # M7075T6S.050
Rel # CHANTAL

ALUMINUM SHEET 7075-T6
0500 Nom X 48.0000" X 144.0000"
AS PER ASTM B209
I/C FROM USA BRANCH

MTR

Page: 1Continued

TOUS LES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

5015-01-21



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26885**

Purchase Order Date 12/23/2014

PO Print Date 12/23/2014

Page Number 1 of 3

Order From:

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"
TORONTO, ON M5W 5V8
CA

VC-COP001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905 649 9444

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

VENDOR'S TRUCK

Buyer Chantal Lavoie

Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference	Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M304S12GA		304/316 0.100" Sheet	1/14/2015 Yes		96.00 sf	\$8.42	\$808.32
MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240								
2	M304S16GA		304/316 Sheet .063	1/16/2015 Yes		320.00 sf	\$5.11	\$1,636.50
MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240								

Line Total:

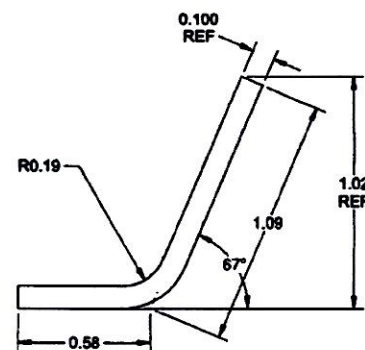
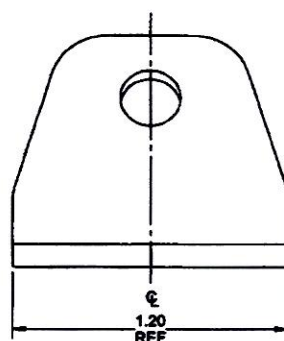
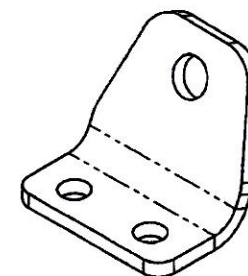
\$808.32

Line Total:

\$1,636.50

Note:

12/23/2014



D5324-1 DRAG BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D5324-1F FLAT PATTERN
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

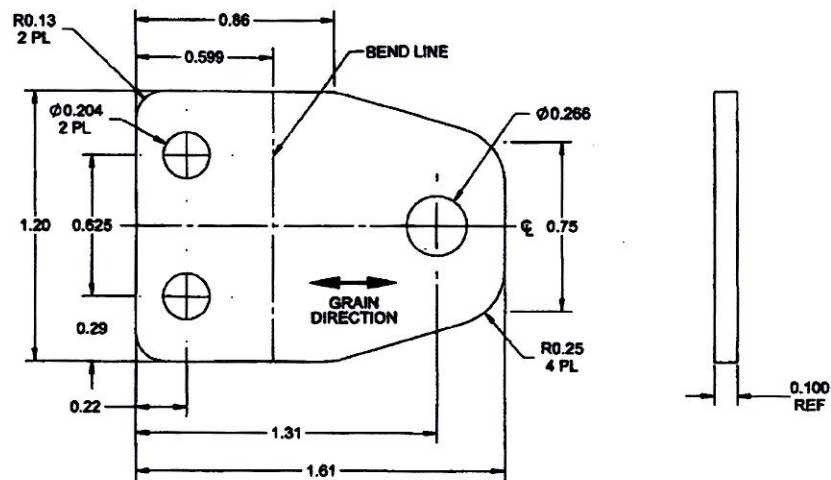
RELEASED
2016-01-21
EAW 16-506

APPROVED

A NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.08.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D5324		SHEET 1 OF 2
TITLE DRAG BRACKET		SCALE NTS

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D5324-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.100 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S12GA OR M303S12GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5324	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DRAG BRACKET	NTS
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